

# Work Order ID 57924

April 20, 2010 10:05:04 AM



Page 1

Item ID: D2857-1

Accept



Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 20/04/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

*RL*

Date: 10-4-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2857

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.2"

*DJP 10/05/25*

*24*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2857-1 □ 2-Deburr any rough edges

*MUE 10/06/01*

*24*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control:

*MUE 10/06/01*

*24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-1 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: \_\_\_\_\_ Date: 10/06/10  
 Resolution: accepted Disposition: use as is QA: N/C Closed: Yes Date: 10/06/10

NCR: 57924		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.06.01	110	Groove is deeper. ≈ 0.140" (dug = 0.125) R.C. tool offset not set correctly : L.O.A.	<u>P</u> 10.06.01 QSI 042	OK. Not critical location	<u>MWZ</u> 10/06/01	<u>cmf</u> 10/06/02	<u>P</u> 10.06.01 QSI 042	<u>S</u> 10/06/03

NOTE: Date & initial all entries

# Work Order ID 57924

April 20, 2010 10:05:04 AM



Page 2


Item ID:	D2857-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Hinge Bracket			Stop		
Start Date:	20/04/2010	Start Qty: 24.00				
Required Date:	29/04/2010	Req'd Qty: 24.00				
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>ml 10/04/02</i>			<i>24</i>	<i>0</i>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00				<i>ml</i>	<i>10</i>	<i>06</i>	<i>03 (24)</i>
150  QC Quality Control	<i>QC5</i> - Inspect part completeness to step on W/O <i>QC3</i> Memo	0.00  0.00							<i>P10 →</i>

W/O: 57924

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/06/08	# 10	Perm change change QCS to QCS		10.06.10			S 12/06/08

Part No: D2857-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Work Order ID 57924

April 20, 2010 10:05:04 AM



Page 3

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 20/04/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:00AM

OVEN TEMPERATURE:

8:30am FINISH TIME:

320°C

=) JH 10/06/08

24

Ø

~~24~~

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(24)

BR 10-6-8

180

Identify as per dwg & Stock Location: 26.

0.00



Packaging

Memo

0.00

Packaging

24

BB

10/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57924**

April 20, 2010 10:05:04 AM



Page 4

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 20/04/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10  
mf  
10-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 20, 2010 10:05:08 AM

Page 1

Work Order ID: 57924



Parent Item: D2857-1



Parent Item Name: Hinge Bracket

Start Date: 20/04/2010

Required Date: 29/04/2010

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐  
IPP ☐ D ☐ 06.05.01 ☐ Added level 8 ☐ EC ☐

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	0.0000	11.0526			



6061-T6 Bar 2.00 x 1.25



Batch # 114307

X 10.4(f)

DTI 10/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	57924
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-1
<b>Inspection Dwg:</b> D2857 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	✓			
4.000	+/-0.010	4.003	✓			
0.340	+/-0.010	0.340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.793	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.003	✓			
0.340	+/-0.010	0.337	✓			
0.447	+/-0.010	0.447	✓			
Ø0.171	+0.005/-0.000	0.174	✓			
0.147	+/-0.010	0.150	✓			
0.376	+/-0.010	0.378	✓			
0.126	+/-0.010	0.122	✓			
0.063	+/-0.010	0.065	✓			
Ø0.166	+0.005/-0.000	0.168	✓			
0.911	+/-0.010	0.914	✓			
0.600	+/-0.010	0.609	✓			
0.125	+/-0.010	0.119	✓			
0.150	+/-0.010	0.152	✓			

<b>Measured by:</b> DIP/m	<b>Audited by:</b> amb	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/05/31	<b>Date:</b> 10/06/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

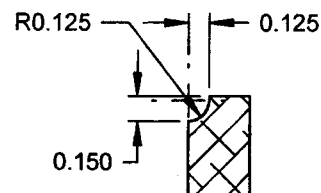
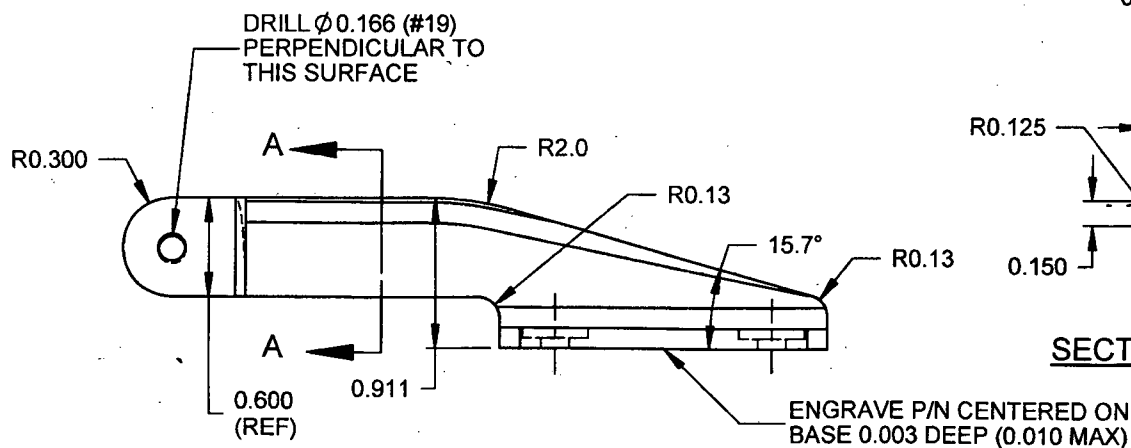
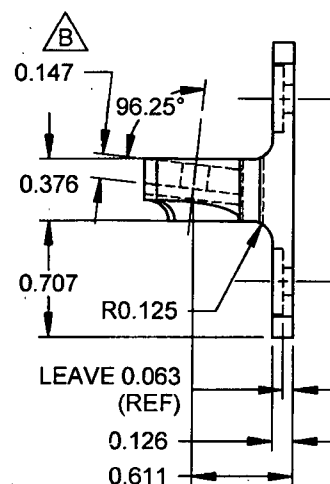
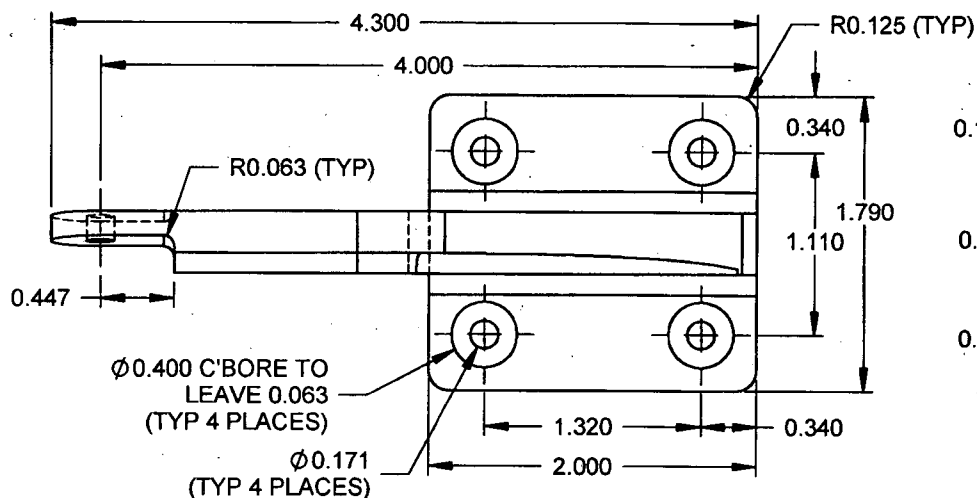
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

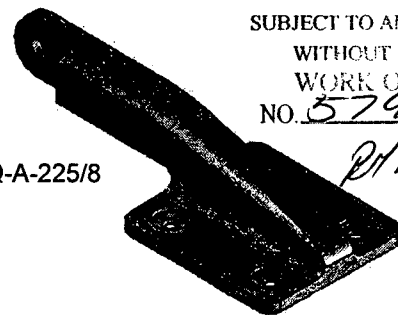
**NOTE:** Date & initial all entries

**DART**

DESIGN KE	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2857</b>	REV. B SHEET 1 OF 1
DATE <b>06.08.28</b>	TITLE <b>HINGE BRACKET</b>		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

**RELEASED**  
06.10.13**SECTION A-A****D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *57929*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Ins.

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	ALS4-1032-130 / Insert	Main Warehouse ST282	61220	QUIR01		197.0000		159.0000		
		Main Warehouse ST282	61586	QUIR01	8/11/10	-16.0000 153.0000	114407	-16.0000 143.0000		-\$2.08
		Main Warehouse ST282	53062	LAVO01	9/03/10	-16.0000 137.0000	114407	-16.0000 127.0000		-\$2.08
		Main Warehouse ST282	61888	DESJ02	9/13/10	-10.0000 27.0000	114407	-10.0000 17.0000		-\$1.30
		Main Warehouse ST282			9/14/10	-17.0000	114407	-17.0000		-\$2.21
								<b>-1,648.0000</b>		<b>-\$214.24</b>
	M6061T6B2.000X01.250 / 6061-T6 Bar 2.00 x 1.25	Main Warehouse MAT	57925	DCUSER		40.0000		40.0000		
		Main Warehouse MAT	57924	FAUT01	5/18/10	-10.9200 29.0800	114407	-10.9200 29.0800		-\$83.96
		Main Warehouse MAT	59612	FAUT01	6/10/10	-10.4000 30.6800	114407	-10.4000 18.6800		-\$79.96
		Main Warehouse MAT	61525	DCUSER	6/14/10	-0.3333 30.3467	114407	-0.3333 18.3467		-\$2.56
		Main Warehouse MAT	61529	DCUSER	9/13/10	-0.7789 29.5678	114407	-0.7789 17.5678		-\$5.99
		Main Warehouse MAT	62795	DCUSER	9/13/10	-0.7789 28.7889	114407	-0.7789 16.7889		-\$5.99
		Main Warehouse MAT	62914	DCUSER	11/02/10	-0.6667 28.1222	114407	-0.6667 16.1222		-\$5.13
		Main Warehouse MAT			11/02/10	-0.6667	114407	-0.6667		-\$5.13
								<b>-24.5445</b>		<b>-\$188.72</b>

*B/N  
should  
reze  
114507*